





# Work Order ID 91959

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**\*91959\***

Page 3

Item ID: D350-591-312

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Heli-Access-Step, Long RH

Stop

**\*NS2\***

Start Date: 10/19/12 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 11/09/12 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

**\*NR1\***

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 <b>*150*</b> QC Quality Control	QC - Inspect Part Finish  Memo	0.00  0.00				10	0		D4 23 89
180 <b>*180*</b> Large Fab Large Fab	Large Fab  Memo 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/RAluminum Rod <u>122358</u> 6-Grind End Plate flush 7-Install last rivet as per Dwg.	0.00  0.00				10	0		Ac 12.11.15 12.11.15 Ac 12.11.15

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**\*N900040100\***

Setup Start \*NS1\*

**Item Name:** Heli-Access-Step, Long RH

Stop \*NS2\*

**Start Date:** 10/19/12      **Start Qty:** 10.00

**\*10\***

**Cust Item ID:**

**Required Date:** 11/09/12      **Req'd Qty:** 10.00

\*10\*

**Customer:**

**Reference:**

**Approvals:** \_\_\_\_\_ **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190

QC10- Inspect visual per QSI004- ground welds

0,00

\*190\*

OC

## Memo

0.00

## Quality Control

200

QC5- Inspect part completeness to step on W/O

0.00

**\*200\***

QC

## Memo

0.00

## Quality Control

210

Chemical Conversion Coat per QSI005 4.1

0.00

**\*210\***

HandFinish

## Memo

0.00

## Hand Finishing

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Item ID: D350-591-312

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**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Heli-Access-Step, Long RH

Stop **\*NS2\***

Start Date: 10/19/12 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 11/09/12 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
<b>*220*</b>									
Powdercoat									
Powder Coating									
	Memo	0.00							
	START TIME: 3:40								
	OVEN TEMPERATURE: 320 °F								
	FINISH TIME: 4:10								
230	Wing Walk as per dwg QSI005 4.4 Batch 122878	0.00							
<b>*230*</b>									
HandFinish									
Hand Finishing									
	Memo	0.00							
240	QC3- Inspect Part Finish	0.00							
<b>*240*</b>									
QC									
Quality Control									
	Memo	0.00							

ML22878

10 X 8  
RH  
12/11/19

DH BL 12/11/20

AS  
15  
12-11-20

10



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Item ID: D350-591-312

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Heli-Access-Step, Long RH

Stop **\*NS2\***

Start Date: 10/19/12 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 11/09/12 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00							
<b>*280*</b>									
QC	Memo	0.00							
Quality Control									

12/11/22  
MF  
12-11-22

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Work Order ID: 91959

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 10/19/12

Required Date: 11/09/12

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A04.03.22New issue KJ/RF  
 IPP Rev:B 07-06-09 Added D3572-1 JLM  
 IPP Rev:C 08-04-02 ECN1163 DD verified by:EC  
 IPP Rev:D 08-04-08 ECN1164 DD verified by:EC IPP Rev:D fixe route seq in bom DD  
 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3272-1 Step		Manufactured	No			110	Each	20.0000	1	10		12.10.31	

Location	Loc Qty	Loc Code
ST	-10	
WA 892140 →	30	
86573	5	
91756	10	
91757	5	

10X

D3067-1  
End Plate

Manufactured No

110 Each 226.0000

1 10

12.10.08

Location	Loc Qty	Loc Code
WA	222	
78608	4	
83855	1	
90177	15	
90178	22	
90335	60	
90336	60	
90486	60	
WA016	4	
67582	2	
68214	1	
79607	1	

10



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Work Order ID: 91959

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 10/19/12

Required Date: 11/09/12

Start Qty: 10.00

Required Qty: 10.00

D3219-1  
Plate

Manufactured No

110 Each 274.0000 2 20

*12.11.08*

Location	Loc Qty	Loc Code
WA	256	
88888	12	
89966	108	
<u>89967</u>	108	<i>20</i>
90704	28	
WA016	18	
73410	12	
77674	6	

D3066-1  
Spacer

Manufactured No

180 Each 179.0000 2 20

*12.11.15*

Location	Loc Qty	Loc Code
WA	179	
90211	30	
<u>90212</u>	60	<i>(14) (6)</i>
<u>90346</u>	29	
90347	60	

MS20600-AD4W4  
Rivets

Purchased No

180 Each 1,578.0000 16 160

*12.11.15*

Location	Loc Qty	Loc Code
321	18	
121652	18	
ST311	1000	
<u>123021</u>	1000	<i>(160)</i>
ST321	560	
121011	9	
121340	39	
121444	512	

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Work Order ID: 91959

Parent Item: D350-591-312

Start Date: 10/19/12

Required Date: 11/09/12

Parent Item Name: Heli-Access-Step, Long RH

Start Qty: 10.00

Required Qty: 10.00

D3065-041 Manufactured No

180 Each 21.0000 1 10

B90012 (X10)  
Ac 12.11.15

Step Leg Assembly Hi

Location	Loc Qty	Loc Code
ST	-30	
WA	21	
66149	0	
79336	1	
88822	5	
90011	15	
WA013	30	

D3067-1 Manufactured No

180 Each 226.0000 1 10

12.11.15

End Plate

Location	Loc Qty	Loc Code
WA	222	
78608	4	
83855	1	
90177	15	
90178	22	
90335	60	
90336	60	
90486	60	
WA016	4	
67582	2	
68214	1	
79607	1	

10

D30350 Purchased No

250 Each 190.0000 2 20

SP12-11-21

Bolt

SMB box

Location	Loc Qty	Loc Code
FG	10	
122800	10	
ST353	180	
123352	180	

20x

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Work Order ID: 91959

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 10/19/12

Required Date: 11/09/12

Start Qty: 10.00

Required Qty: 10.00

**D3235-1** Manufactured No

Mounting Lug

Sms 10x

250 Each 126.0000

2

20

SP

SP

Location

Loc Qty

Loc Code

ST470

126

90002

126

**D3278-041** Manufactured No

Support Assembly

Sms 10x

250 Each 0.0000

**AN960JD416**

NAS1149D0463J

Purchased No

250 Each 29.0000

Washer

Sms 10x

Location

Loc Qty

Loc Code

ST351

29

116289

8

119097

21

**AN960JD516** Purchased No

Washer

NAS1149D0563J

250 Each 2.0000

4

40

SP 10 389974 2x 389973 8x  
160 m/23355 SP

Sms 10x

Location

Loc Qty

Loc Code

ST338

2

1069059

2

**AN5-36A** Purchased No

Bolt

Sms 10x

250 Each 46.0000

2

20

m/23525 SP

Location

Loc Qty

Loc Code

ST338

46

123021

46

**D2618** Manufactured No

Bushing

Sms 10x

250 Each 5.0000

2

20

SP 20 3892530 20x  
12-11-20

Location

Loc Qty

Loc Code

ST013

5

76130

2

84646

3

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Work Order ID: 91959

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 10/19/12

Required Date: 11/09/12

Start Qty: 10.00

Required Qty: 10.00

**D2230-3** Manufactured No  
Lug

250 Each 316.0000

**40**  
B89082.3x.  
B92287.34x.

Sm  
107

Location	Loc Qty	Loc Code
FG	1	
89045	1	
ST469	315	
89782	19	
89950	200	
90514	96	

**D2856-400** Manufactured No  
Abrasion Strip

250 f 409.2539

**12**  
3x  
12  
SP 12-11-20.

Sm  
107

Location	Loc Qty	Loc Code
ST403	120.2525	
81875	6.398	
89352	113.8545	
ST408	216	
90764	216	
ST409	73.0014	
63735	0.6696	
68076	0.3149	
71164	8.46	
86905	63.5569	

12x

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Work Order ID: 91959

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 10/19/12

Required Date: 11/09/12

Start Qty: 10.00

Required Qty: 10.00

**MS21042L3** Purchased No

250 Each 3,340.0000 2

20

Nut

Location Loc Qty Loc Code

316 651

122452 651

ST300 338

117885 32

119017 168

119075 138

ST314 1831

123265 1831

ST317 520

122141 520

**AN3-13A** Purchased No

250 Each 1,002.0000 8

80

Bolt

Location Loc Qty Loc Code

ST356 809

122416 287

122808 22

122993 500

ST357 193

120187 19

120770 12

121652 161

122063 1

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Work Order ID: 91959

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 10/19/12

Required Date: 11/09/12

Start Qty: 10.00

Required Qty: 10.00

MS21042L5

Purchased

No

250

Each

1,253.0000

2

20

SP

Nut

SMS 10x

## Location

## Loc Qty

## Loc Code

300	173	
121652	173	
314	1000	
122452	1000	20x
ST300	80	
108827	4	
116105	1	
116548	43	
119109	20	
2937	12	

MS21042L4

Purchased

No

250

Each

5,326.0000

8

80

SP

Nut

SMS 10x

## Location

## Loc Qty

## Loc Code

314	1399	
122452	1399	
ST300	27	
119017	20	
121444	7	
ST314	3900	
123021	3000	80
123248	900	

AN960JD10

NAS1149D0363J

Purchased

No

250

Each

0.0000

4

40

17122378

Washer

SMS 10x

SP 12-11-20

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Shop Packet Print

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DESIGN <i>qp</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

**RELEASED**

07.06.04 *[Signature]*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

**GENERAL NOTES:**

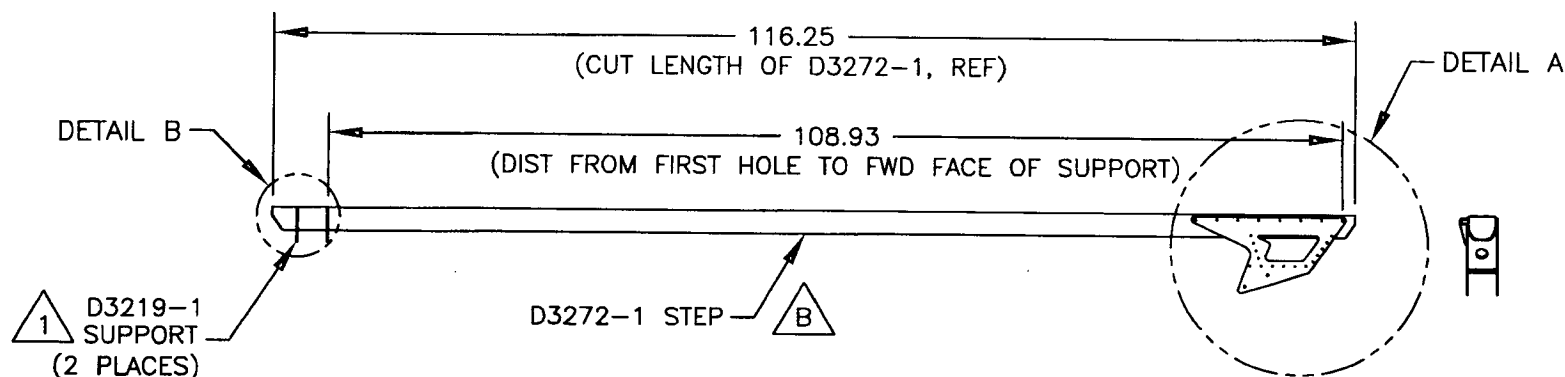
- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

12-10-22  
91959 MJS  
UNCONTROLLED  
INFORMATION  
DO NOT  
USE FOR  
PRODUCTION  
WORK  
WITHOUT  
WRITTEN  
PERMISSION  
FROM  
DART  
AEROSPACE  
LTD

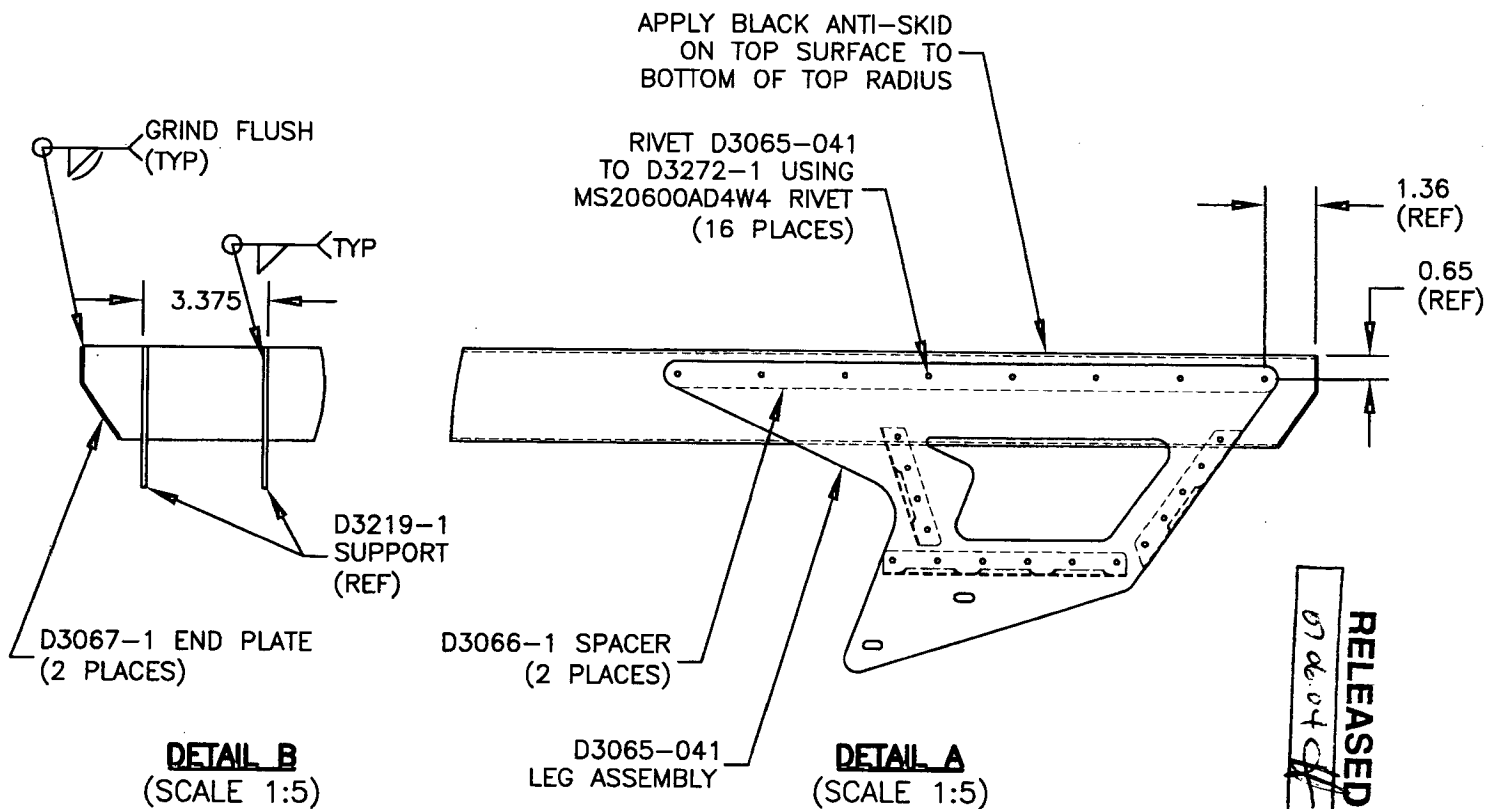
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91959

**DART**

**D3272-041 STEP ASSEMBLY (LH. SHOWN)**  
**D3272-042 STEP ASSEMBLY (RH, OPPOSITE)**



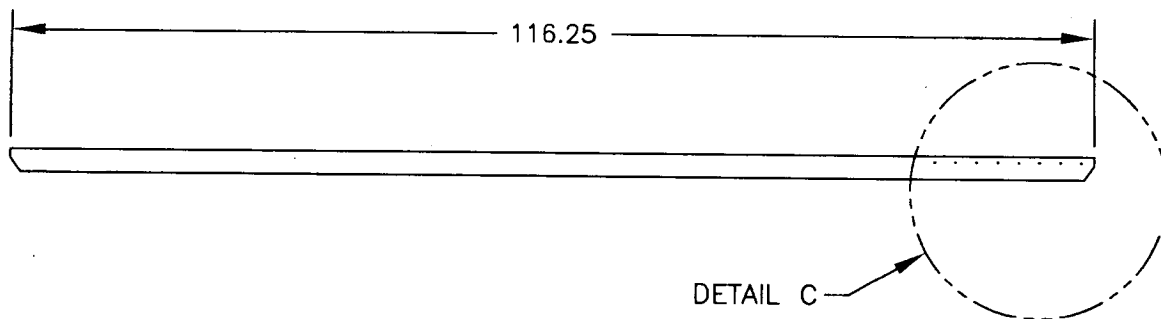
DESIGN <b>90</b>	DRAWN BY <b>[Signature]</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
CHECKED <b>[Signature]</b>	APPROVED <b>[Signature]</b>	REV. B
DATE 07.05.18	DRAWING NO. D3272	SHEET 2 OF 3
	TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20



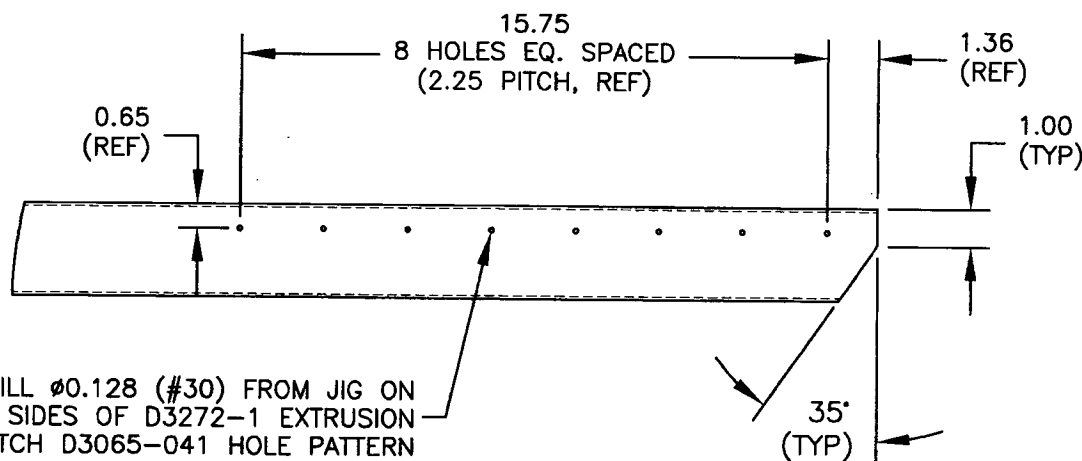
91959

**DART**

DESIGN	90	DRAWN BY	JS	DART AEROSPACE LTD
CHECKED	CE	APPROVED	JS	HAMKESBURY, ONTARIO, CANADA
DATE	07.05.18	TITLE	STEP ASSEMBLY, HI LONG	REV. B
		DRAWING NO.	D3272	SHEET 3 OF 3
		SCALE	1:20	



**△ B D3272-1 STEP**  
(MAKE FROM D2622-120 STEP EXTRUSION)



**DETAIL C**  
(SCALE 1:5)

**RELEASED**

07.06.04